

Work Order ID 105679

Monday, August 12, 2013 9:12:16 AM

105679

Page 1

Item ID: D350-588-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Assembly

Start Date: 9/20/2013 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/20/2013 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: CL Date: 13/08/12 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

ASR

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

DAS
31
9-89

14-04-4

1

110

0.00

110

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 20894
Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

CL

13/08/12 ①

Work Order ID 105679

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Page 2

Item ID: D350-588-041

Revision ID:

Item Name: Aft Door Assembly

Start Date: 9/20/2013 Start Qty: 1.00

Required Date: 9/20/2013 Req'd Qty: 1.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

66 13/11/28 (1)

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

Inspect as per Dwg D2445.
Audit process sheet.DAS
16
9-89

14/64/02

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Assemble all of the above parts as per Dwg D350-588

14 04 02 (x1)

Work Order ID 105679

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Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 9/20/2013 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/20/2013 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours DASTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

Quality Control

0.00

155

Pick Kit

0.00

155

Packaging

Memo

Packaging

0.00

160

QC4- 100% Inspect kits for completeness

0.00

160

QC

Memo

Quality Control

0.00

DAS
31
9-89

14-04-3

1x

SP14-4-2

Work Order ID 105679

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Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 9/20/2013 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/20/2013 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp
9-89

170

Identify as per dwg & Stock Location: D31A

0.00

170

Packaging

Memo

0.00

Packaging

APR -4 2014

DA
06
9-89

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

14/4/9 28
② 14.04.04

Picklist Print

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Page 1

Work Order ID: 105679
Parent Item: D350-588-041
Parent Item Name: Aft Door Assembly

Start Date: 9/20/2013 Required Date: 9/20/2013
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as per DSI9414 DD
verified by:EC IPP Rev:R add pick kit DD 10.03.29 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R7 Screw		Purchased	No			155	Each	134.0000	2	2			DAS 26 9-89

DAS
31
9-89

Location	Loc Qty	Loc Code
ST346	134	
123831	34	
M126175	100	

AN526C832R8
Screw

Purchased No

155 Each 152.0000

8-1 MD7817. DAS
26
9-89

DAS
31
9-89

Location	Loc Qty	Loc Code
ST345	16	
122814	8	
123522	8	
ST516	136	
125388	136	

AN526C832R9
Screw

Purchased No

140 Each 658.0000

126403 * 8 8 14-04-02

Location	Loc Qty	Loc Code
ST345	649	
M126105	263	
M126474	386	
ST516	9	
125388	9	

AN960JD10 WASHER NAS1149D0363J Purchased No

140 Each 0.0000

127813 2 2 14-04-02

AN960JD10 WASHER NAS1149D0363J Purchased No

155 Each 0.0000

2 2 MD7813 14-4-3 DAS
26
9-89

DAS
31
9-89

DAS
26
9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Work Order ID: 105679

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/20/2013

Required Date: 9/20/2013

Start Qty: 1.00

Required Qty: 1.00

D2143 Manufactured No
Hinge Bracket

140 Each 10.0000

1 1

4514.04-02

Location Loc Qty Loc Code

ST005 10

98391 10

XL

D2144 Manufactured No
Hinge Doubler

140 Each 3.0000

1 1

4514.04-02

Location Loc Qty Loc Code

ST005 3

92181 3

B100467 x1

D2150
Packer Doubler, Hinge
DAS
31
9-89

Manufactured No

155 Each 5.0000

2 2 B112962 DAS 26 9-89

Location Loc Qty Loc Code

ST005 5

95890 5

D2151
Packer Doubler

Manufactured No

155 Each 8.0000

2 2 B106821 DAS 26 9-89

Location Loc Qty Loc Code

ST005 8

95852 8

D2153
Door Prop

Manufactured No

155 Each 64.0000

1 1 14-4-2. B114286 DAS 26 9-89

Location Loc Qty Loc Code

FG 5

85865 5

ST260 59

100934 36

101672 23

DAS
06
9-89

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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Work Order ID: 105679

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/20/2013

Required Date: 9/20/2013

Start Qty: 1.00

Required Qty: 1.00

D2154
Bracket, Stud

Manufactured No

155 Each 24.0000

1 1

DAS
26
9-89

DAS
31
9-89

Location Loc Qty Loc Code

ST005 18
100839 12
98950 6
ST006 6
82333 6

/X

D2237
Striker Plate

Manufactured No

155 Each 66.0000

2 2 B 105708

DAS
26
9-89

DAS
31
9-89

Location Loc Qty Loc Code

ST007 66
102727 20
104470 21
93697 10
96996 15

D2445P
AFT DOOR ASSEMBLY

Purchased No

110 Each 0.0000

1 1

105679

DAS
32
9-89

D2461
Seal(per foot)

Manufactured No

155 f 705.0539

7.25 7.25

(D2461-0870) cut (1) at 87.00"
**** per kit***

DAS
31
9-89

Location Loc Qty Loc Code

ST402 387.06
102517 387.06
ST415 317.993894
39782 6.5
55054 4
63880 14.8237
73644 113.702984
85225 178.96721

7.25

SP 4-4

DAS
27
9-89 1487"

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NCR: Yes / No

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

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Work Order ID: 105679
 Parent Item: D350-588-041
 Parent Item Name: Aft Door Assembly

Start Date: 9/20/2013 Required Date: 9/20/2013
 Start Qty: 1.00 Required Qty: 1.00

D2463 Manufactured No
 1/2" Seal (\$per foot)
 (D2463-0870) cut (1) at 87.00"
 **** per kit***

B110718 140 f 477.1282 7.25 7.25 ET 14-04-02

Location	Loc Qty	Loc Code
ST403	477.1281745	
72232	15.38	
79478	0.43737	
83542	0.04291	
90297	14.57	
95774	54.6278945	
98335	392.07	

D2585 Manufactured No
 Latch Clamp

B110344 140 Each 42.0000 2 2 ET 14-04-02

Location	Loc Qty	Loc Code
ST012	42	
100527	16	
101805	25	
99063	1	

D2586 Manufactured No
 Door Latch

113641 140 Each 96.0000 2 2 ET 14-04-02

Location	Loc Qty	Loc Code
FG	13	
100607	2	
83893	10	
95760	1	
return2013	3	
xxxxx	3	
ST203A	80	
100607	80	

D2589 Manufactured No
 Keys, Key Chain

155 Each 68.0000 1 1 14-4-21

DAS
 31
 9-89

Location	Loc Qty	Loc Code
ST012	68	
58194	68	

1X

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NCR: Yes / No

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

Picklist Print

Monday, August 12, 2013 9:12:14 AM

Page 5

Work Order ID: 105679

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/20/2013

Required Date: 9/20/2013

Start Qty: 1.00

Required Qty: 1.00

D2621-11
Latch Plate

Manufactured No

140 Each 26.0000

2 ~~14-04-02~~

115195 x2

Location Loc Qty Loc Code

FG 2

88616 2

ST014 24

88616 24

D2690-17
Cable

Manufactured No

155 Each 24.0000

1 1

DAS
26
9-89

14-4-2

Location Loc Qty Loc Code

ST016 24

100261 2

100752 10

102311 4

91824 4

94470 4

DAS
31
9-89

1X

D2857-1
Hinge Bracket

Manufactured No

140 Each 30.0000

1 1

14-04-02

106185

Location Loc Qty Loc Code

FG 5

82261 4

91914 1

ST019 25

100965 22

91914 1

95859 2

D2857-2
Hinge Bracket

Manufactured No

140 Each 32.0000

1 1

14-04-02

Location Loc Qty Loc Code

FG 3

78904 3

ST019 29

100769 24

95712 5

X1

Monday, August 12, 2013 9:12:14 AM

Shop Packet Print

Page 5

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
---	---	---

<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	---

Picklist Print

Monday, August 12, 2013 9:12:14 AM

Page 6

Work Order ID: 105679

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/20/2013

Required Date: 9/20/2013

Start Qty: 1.00

Required Qty: 1.00

DAS
26
9-89

D2858-1
Hinge Bracket

Manufactured No

155 Each 34.0000

1 1

Location Loc Qty Loc Code

FG 2
77019 2
ST019 32
100756 12
82337 1
95701 19

DAS
31
9-89

D2858-2
Hinge Bracket

Manufactured No

155 Each 21.0000

1 1 B/65555

Location Loc Qty Loc Code

FG 2
77020 2
ST020 19
95851 19

DAS
31
9-89

FG-778150-550-ROL
7781 9oz Glass 10x125yd

Purchased No

155 sf 756.1600

1 1 m127570

CUT ONE SQUARE FEET PER KIT
9-89

Location Loc Qty Loc Code

CA 756.16
123239 756.16

MS20426AD3-4
RIVET

Purchased No

155 Each 17,470.000

12 12 14-4-2

Location Loc Qty Loc Code

ST334 1326
123164 1326
ST505 8024
104374 12
123021 12
124814 8000
ST509 8120
124586 120
125578 8000

DAS
31
9-89

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Shop Packet Print

Page 6

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

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Page 7

Work Order ID: 105679
 Parent Item: D350-588-041
 Parent Item Name: Aft Door Assembly

Start Date: 9/20/2013

Required Date: 9/20/2013 DAS 26 9-89

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-5

Purchased No

RIVET, UNIVERSAL HEAD

DAS
31
9-89

Location

Loc Qty

Loc Code

ST336

651

125654

651

MS21042L08

Purchased No

Nut

Location

Loc Qty

Loc Code

ST315

1217

122141

3

122452

9

122814

500

123900

705

ST505

2000

125445

2000

MS21042L08

Purchased No

Nut

DAS
31
9-89

Location

Loc Qty

Loc Code

ST315

1217

122141

3

122452

9

122814

500

123900

705

ST505

2000

125445

2000

651.0000

Each

155

18

18

m/26926

3,217.0000

Each

140

8

8

AT 14-04-02

3,217.0000

Each

155

10

10

14-4-2

DAS
26
9-89

10x

Monday, August 12, 2013 9:12:15 AM

Shop Packet Print

Page 7

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	---

Picklist Print

Monday, August 12, 2013 9:12:15 AM

Page 8

Work Order ID: 105679

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/20/2013

Required Date: 9/20/2013

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140

Each

7,307.0000

2

2

Nut

127410

21 14-04-02

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

831

111668

1

117885

32

119017

55

119075

138

123265

43

M126036

562

ST506

1455

123900

912

124291

543

ST510a

5000

M126275

1000

M126333

4000

Monday, August 12, 2013 9:12:15 AM

Shop Packet Print

Page 8

Picklist Print

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Page 9

Work Order ID: 105679
 Parent Item: D350-588-041
 Parent Item Name: Aft Door Assembly

Start Date: 9/20/2013

Required Date: 9/20/2013

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Nut

Purchased

No

155

Each

7,307.0000

4

4

m1274/10

DAS

26

9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

831

111668

1

117885

32

119017

55

119075

138

123265

43

M126036

562

ST506

1455

123900

912

124291

543

ST510a

5000

M126275

1000

M126333

4000

MS27039-08-11

SCREW

Purchased

No

155

Each

946.0000

2

2

14-4-2

DAS
31
9-89

Location

Loc Qty

Loc Code

ST307

660

122441

100

123352

500

123900

60

ST308

286

125654

286

MS27039-1-15

Screw

Purchased

No

140

Each

854.0000

2

2

ST 14-04.02

Location

Loc Qty

Loc Code

ST506

854

124326

854

Monday, August 12, 2013 9:12:15 AM

Shop Packet Print

Page 9

Picklist Print

Monday, August 12, 2013 9:12:15 AM

Page 10

Work Order ID: 105679
 Parent Item: D350-588-041
 Parent Item Name: Aft Door Assembly

Start Date: 9/20/2013 Required Date: 9/20/2013
 Start Qty: 1.00 Required Qty: 1.00

NAS1149DN832J Purchased No
 Washer

127813 140 Each 5,183.0000 8 8 ET 14 04 02

Location	Loc Qty	Loc Code
ST293	1183	
123603	5	
124555	398	
M126221	780	
ST510a	4000	
M126319	4000	

NAS1149DN832J Purchased No
 Washer

~~127813~~ 155 Each 5,183.0000 16 16 M127813 14-4-2

Location	Loc Qty	Loc Code
ST293	1183	
123603	5	
124555	398	
M126221	780	
ST510a	4000	
M126319	4000	

DAS
 31
 9-89

DAS
 28
 9-89

Monday, August 12, 2013 9:12:15 AM

Shop Packet Print

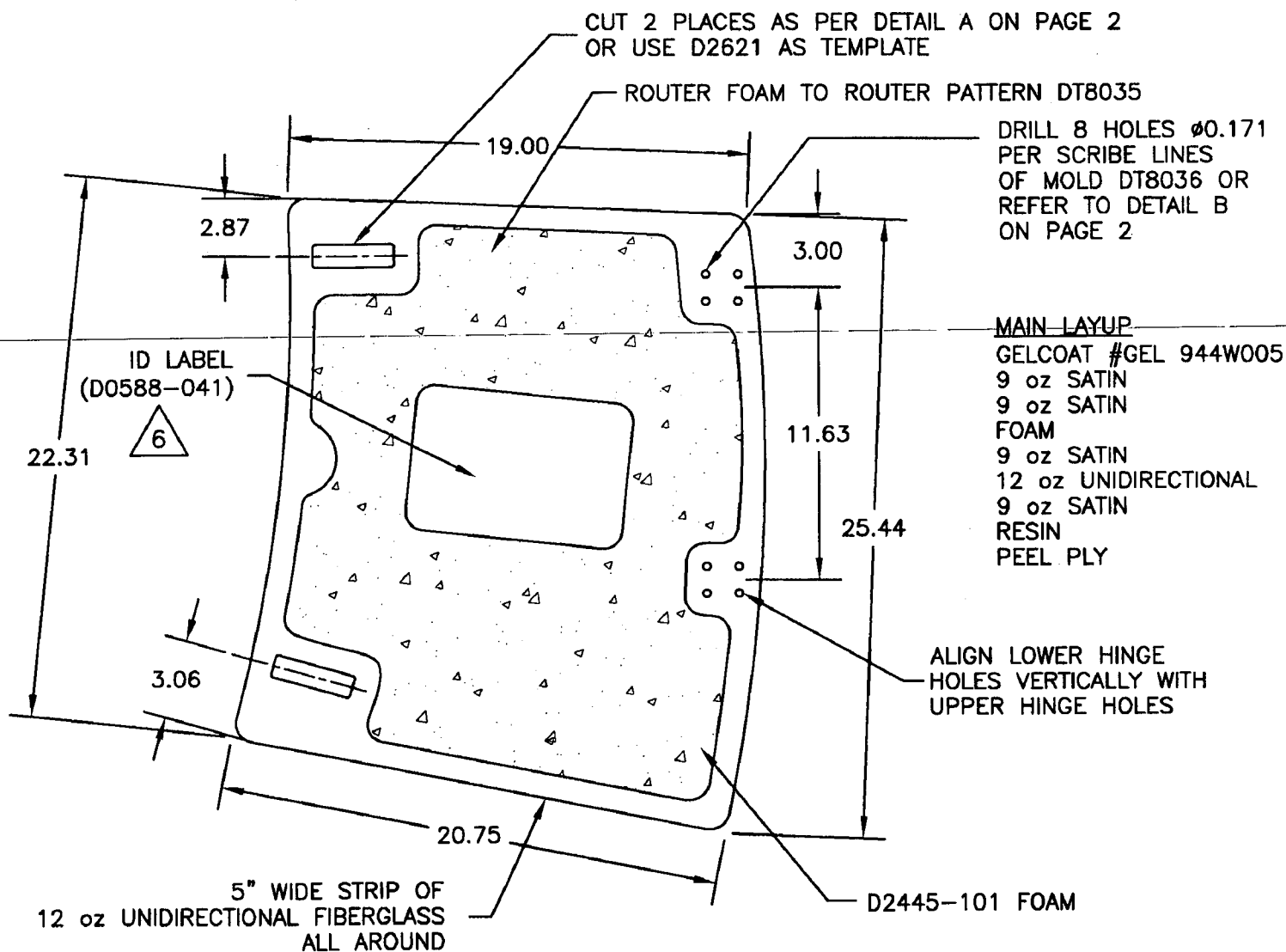
Page 10



DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR	SCALE 1:7	
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED

06.11.13 *[Signature]*



NOTES:

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DMVYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

CL 13/08/12
W10.105679

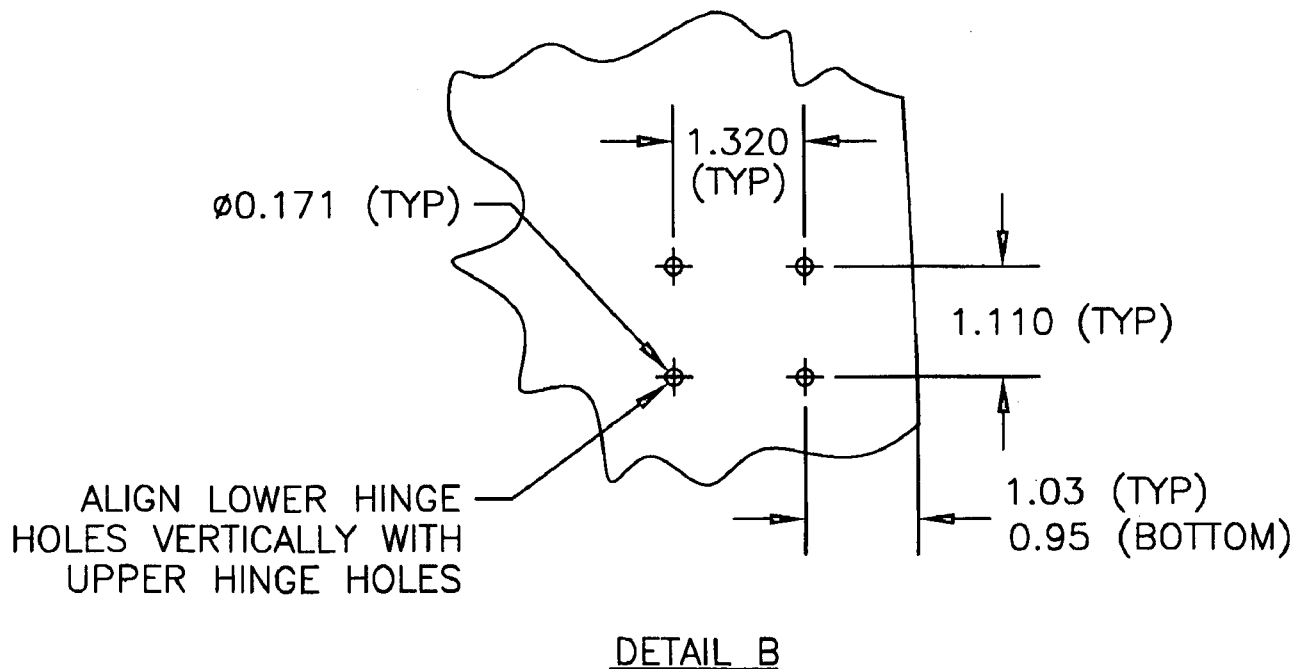
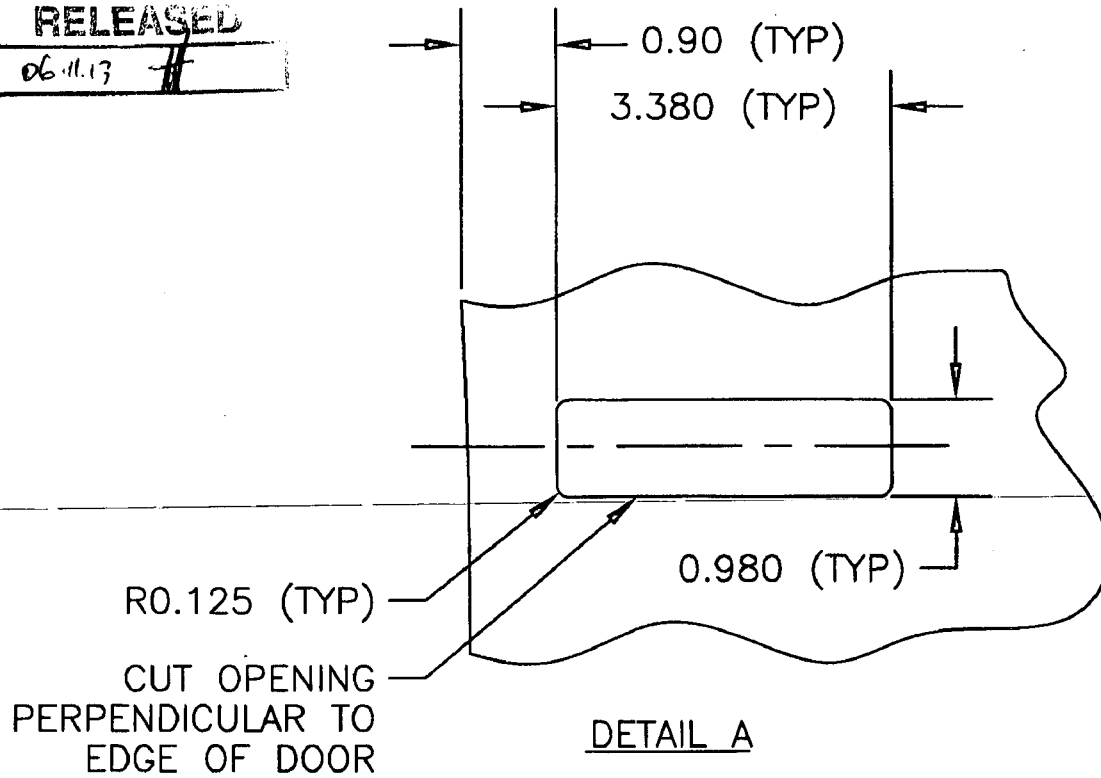
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED
06.11.13 *[Signature]*





DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	49949
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
26-11-2013	29-08-2013	23794	Chantal Lavoie	20894	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX PI Collect		Point de départ		Mathieu Doucet, ext.690	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0013	Line 2 D350-588-041 Aft Baggage Door (D2445) U of M: Chaque Drawing N° : D2445 Rév.: D Serial # Lot # 55107 55107	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department



~~AO-357~~

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2013-08-22 07:55:08
Utilisateur: marc dubé

Feuille de Procédé

Client :	DART US DART AEROSPACE	Nom Dessin :	N° D2445, AFT BAGGAGE DOOR
Numéro Job :	55107	Numéro Article :	DKC134-0013
Numéro :	3959	Numéro Dessin :	-
Numéro B.A. :		Projet Numéro :	DK-362
Cette fois :	2013-08-22 No. :	Révision dessin :	
Prsht Rev. :	NC	Matériel :	Composite
Prem. fois :	-- Type :	Date Dûe :	2013-08-29
Job précédente :	54566	Qté:	1 Ud UNITE

Écrit par : _____

Vérifié & Approuvé par : _____

Commentaires : N° de pièce Client: D2445 rev. D



19 Sept
RNC 7847
9082013 IV.



E.O.: N/A

Feuille de Procédé Rév.: 04 déplacer collage du label
après primer, ajout 2ieme étape de finition et de primer

Formulaire d'inspection: N/A

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
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1.0	AAC1616	N° 83634, Frekote Loctite Wolo
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Comment Qty.: 0.200 UNITE(s)/Unit Total : 0.200 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 1-37420-1

2.0	PREP-GENERAL	Préparation du matériel
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Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT-8036 selon IG 0009.

Date: 16/09/13



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
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Comment Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-39457-1

4.0	AMB0286	Catalyst N° DDM-9
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Comment Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0	PREP-GENERAL	Préparation du matériel
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Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par
quantité de résine.

Date: Jeudi, 2013-08-22 07:55:08

Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	55107	Numéro	DKC134-0013
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	Date: <u>16/09/13</u> Sceau: 		
6.0	GEL COAT	Application du Gel Coat	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Faire l'application du Gelcoat selon IG 0019		
	Date: <u>16/09/13</u> Sceau: 		
7.0	AAC1885	Tissu à délaminer Release ply B	
Comment	Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s) Tissu à délaminer Release ply B # de Lot: <u>N/A</u>		
8.0	AAC1887	Wrightlon 5200 Bleu P3	
Comment	Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s) Wrightlon 5200 Bleu P3 # de Lot: <u>N/A</u>		
9.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment	Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)		
10.0	AC0943	Stretchlon 200 poche à vide Vert	
Comment	Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)		
11.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Comment	Qty.: 2.00 VERGE(s)/Unit Total : 2.00 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: <u>1-41291-1</u>		
12.0	AMB0511	N° TG-13-U, Fiberglass 13 oz	
Comment	Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s) N° TG-13-U, Fiberglass 13 oz N° de Lot: <u>1-36302-1</u>		
13.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment	Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)		
14.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Tailler le matériel, selon les différents patrons de découpe comme suit:		
	4 plis de tissus de 9.7 oz.		
	1 pli de 13 oz. pour tout le contour de la pièce par 5" de large.		
	3 fois le sac à vide Stretchlon 200.		
	3 fois le film perforé P-3		
	3 fois le feutre de drainage		
	2 fois le tissu à délaminer (non nécessaire lors du bagging du core).		
	Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.		

Date: Jeudi, 2013-08-22 07:55:08
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 55107

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 13/09/13 Sceau: 56

15.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

16.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-42176-1

17.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 17/09/13 Sceau: 4460 R.L. 56

18.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 17/09/13 Sceau: 4460 R.L. 56

19.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.










Heure Curing début: 18:45 Heure Curing Fin: 8:00

Date: 17/09/13 Sceau: 4460 R.L. 56

Date: Jeudi, 2013-08-22 07:55:08

Utilisateur: marc dubé











Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 55107	Numéro DKC134-0013	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
20.0	AMB0286	Catalyst N° DDM-9
Comment Qty.: 0.0042 GALLON(s)/Unit Total: 0.0042 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>27029-1</u>		
21.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-42170-1</u>		
22.0	PREP-GENERAL	Préparation du matériel
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105. Date: <u>05-09-13</u> sceau: <u>4460 RL</u>		
23.0	AAC1611	Polybond B46F
Comment Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s) Polybond B46F N° de Lot: <u>1-38189-1</u>		
24.0	DKC134-0029	Foam Core N° D2445-101 (Pour AFT Baggage Door)
Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: <u>55112</u>		
25.0	ASSEMBLAGE	Assemblage mécanique
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Assembler le DKC134-0029 selon IG 0033 Date: <u>08/09/13</u> sceau: <u>4460 R.L.</u> 		
26.0	BAGGING	Faire le bagging sur la pièce
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012 Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond. Heure début Curing: <u>12:30</u> Heure Fin Curing: <u>2:00</u> Date: <u>08/09/13</u> sceau: <u>4460 R.L.</u> 		

Date: Jeudi, 2013-08-22 07:55:08

Utilisateur: marc dubé












Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 55107	Numéro DKC134-0013	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
27.0	AMB0286	Catalyst N° DDM-9
Comment	Qty.: 0.1360 GALLON(s)/Unit Total : 0.1360 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>	
28.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment	Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-42176-1</u>	
29.0	PREP-GENERAL	Préparation du matériel
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350. Date: <u>19/09/13</u> Sceau: <u>4460 R.L.</u> 	
30.0	LAMINAGE	Faire le laminage
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le laminage d'un pli de 9.7 oz. Faire le laminage du plis de tissu 13 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent Faire le laminage du dernier pli de 9.7 oz. Date: <u>19/09/13</u> Sceau: <u>4460 R.L.</u> 	
31.0	BAGGING	Faire le bagging sur la pièce
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012 Laisser sécher pendant 4 heures minimum. Heure Curing Début: <u>3:00</u> Heure Curing Fin: <u>8:00</u> Date: <u>19/09/13</u> Sceau: <u>4460 R.L.</u> 	

Date: Jeudi, 2013-08-22 07:55:08








Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	55107	Numéro	DKC134-0013
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
32.0	DÉMOULAGE	Démoulage de la pièce	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Démouler la pièce en faisant bien attention aux coins & Edges.			
Date: <u>23/09/13</u> Sceau: 			
33.0	TRIMAGE	Trimage	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
À l'aide du gabarit N°DT-8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.			
Percer les " Latch " et les trous de penture selon le dessin N° D2445.			
Date: <u>24-09-13</u> Sceau: <u>446081</u>			
34.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-41428-1</u>			
35.0	FINITION	Finition Générale	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.			
Date: <u>24-09-13</u> Sceau: <u>446081</u>			
36.0	AAC1021	Dupont Primer N° 7704S	
Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-42451-1</u>			
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-41909-3</u>			
38.0	PRIMER	Application primer	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la préparation et l'application du primer batisseur selon I.G. 0008			
Date: <u>26-09-13</u> Sceau:  # de fiche de mélange: <u>6472</u>			

Date: Jeudi, 2013-08-22 07:55:08
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	55107	Numéro	DKC134-0013
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
39.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment	Qty.: 0.014 GALLON(s)/Unit Total: 0.014 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-41422-1</u>		
40.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/Run: 0.0000Min Total Run: 0.0000Hrs Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3. Date: <u>27-09-13</u> Sceau: <u>4460 RL</u>		
41.0	AAC1605	Label N° D0588-041	
Comment	Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) Label N° D0588-041 N° de Lot: <u>N/A</u>		
42.0	AAC1609	Surface Veil	
Comment	Qty.: 0.07 VERGE(s)/Unit Total: 0.07 VERGE(s) Surface Veil N° de Lot: <u>N/A</u>		
43.0	AAC1220	Résine Mia-Poxy 100	
Comment	Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s) Résine Mia-Poxy 100 N° de Lot: <u>130095-B</u>		
44.0	AAC1221	Durcisseur 95 Pour Résine Mia-Poxy	
Comment	Qty.: 0.007 QUART(s)/Unit Total: 0.007 QUART(s) Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: <u>1-34505-A</u>		
45.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/Run: 0.0000Min Total Run: 0.0000Hrs Coller le label N° D0588-041 selon IG 0111. Date: <u>30-09-13</u> Sceau: <u>4460 RL</u>		
46.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-4245A1</u>		
47.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-41909-3</u>		
48.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/Run: 0.0000Min Total Run: 0.0000Hrs Faire la préparation et l'application du primer final selon I.G. 0008		

Date: Jeudi, 2013-08-22 07:55:08

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 55107

Numéro DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 21/01/13

Sceau:



de fiche de mélange: 6475

49.0

INSPÉC FINAL

Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: 26/11/13

Sceau:



50.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Date: 26/11/13

Sceau:

44S15m